

**ALEXIT<sup>®</sup>**  
**FST-Füllgrund 343-55 (Filler primer)**

Data sheet: 343-55  
Technical info:  
Gen. techn. info:

- 1. Introduction/Characteristics** ALEXIT-FST-Füllgrund 343-55 is a water-dilutable two-component paint based on polyurethane with high filling qualities. The material's FST-properties (Fire, Smoke, Toxicity) meet the Airbus requirements of ABD 0031 as well as international standards such as FAR 25.853 (a) + (b) and FAR 25.853 (a-1), Amdt. 66 (65/65).
- ALEXIT-FST-Füllgrund 343-55 was qualified by Airbus and is in accordance with AIMS 04-08-001 and the technical delivery conditions of AIMS 04-08-000.
- ALEXIT-FST-Füllgrund 343-55 offers excellent adhesion on many kinds of plastic. Due to the material's high filling power uneven surfaces and flow lines can be covered with a one-layer coating. ALEXIT-FST-Füllgrund 343-55 can be used as a filling intermediate coat or as a primer.
- After curing, ALEXIT-FST-Füllgrund 343-55 is easily sandable, while at the same time being very solid and an ideal base for top coats.
- 2. Range of Application** for application in the interior of aircraft, ships, automobiles and trains
- 3. Colour** ivory, silver grey
- 4. Coverage** 4 m<sup>2</sup> / kg –dry film thickness:80 µm  
recommended dry film thickness: 50 to 100 µm
- 5. Substrate Pretreatment** In many cases ALEXIT-FST-Füllgrund 343-55 can be applied directly onto the appropriately cleaned / pretreated metal or thermoplastic substrate. On metal substrates adhesion may be improved by chemical pretreatment (phosphatizing, chromating).
- 6. Trade names**
- |               |                               |
|---------------|-------------------------------|
| Base Material | ALEXIT-FST-Füllgrund 343-55   |
| Hardener      | ALEXIT-Härter 345-15          |
| Thinner       | Water (≤ 20° German hardness) |
- For further information on the application of water-dilutable materials please see our technical information ATI B2.

# ALEXIT®

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### 7. Mixing ratio

15 parts by weight	ALEXIT-FST-Füllgrund
1 part by weight	ALEXIT-Härter
10 parts by volume	ALEXIT-FST-Füllgrund
1 part by volume	ALEXIT-Härter

When ALEXIT-Härter 345-15 is mixed with the basic paint, a high speed mixer has to be used for 1 to 2 minutes.

The VOC content is 131 g/l (use of thinner: 10 %).

### 8. Application

High filling

Compressed air spraying	max. 5 % thinner
Efflux time (ISO 2431, Ø 6 mm)	approx. 15 seconds

Complicated,  
large parts

Compressed air spraying	10 % thinner
Efflux time (ISO 2431, Ø 6 mm)	approx. 10 seconds

Due to thixotropic properties the efflux time can only be measured after careful stirring of the material.

Nozzle size	1,5 - 1,8 mm
Pressure	3,0 - 4,0 bar

### 9. Pot life

Room temperature	approx. 3 hours
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### 10. Drying

Room temperature	dust free	: approx. 20 min.
20° C und 60 % rel. humidity	assembly dry	: approx. 4 hours
	sandable	: approx. 7 hours
	fully cured	: approx. 7 days

Oven drying	1 - 2 hours flash-off time, 2 hours at 60° C or 30 minutes at 80° C
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### 11. Packaging

ALEXIT-FST-Füllgrund 343-55	10 kg net
ALEXIT-Härter 345-15	1 kg net

### 12. Storage

storage temperature	5 to 25 °C; keep from frost
storage ability	base material: 12 months hardener: 12 months